

Work Order ID 77331

77331

Ship ASAP

Page 1

Monday, December 05, 2011 11:23:29 AM

Item ID: D2842-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Assembly, 206 Float
 Start Date: 12/5/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MF Date: 11-12-05 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2842	Rev B

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100 Large Fab

Large Fab Memo 0.00

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
 2-Drill D2842-1 using Jig DT8271 as per Dwg D2842
 3-Deburr and bevel ends for welding

110	QC6- Inspect dimensions to drawing	0.00							
-----	------------------------------------	------	--	--	--	--	--	--	--

110 QC

Quality Control Memo 0.00

120	Weld per dwg A/R Aluminum rod Batch: 114514 119712	0.00							
-----	---	------	--	--	--	--	--	--	--

120 Large Fab

Large Fab Memo 0.00

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per
 Dwg D2842

2-Grind end cap weld flush

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77331***77331***

Page 2

Monday, December 05, 2011 11:23:29 AM

Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly, 206 Float
Start Date: 12/5/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/12/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1	0	BE12-01-11	
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		81260613		(81)			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	0		12.01.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77331

Monday, December 05, 2011 11:23:29 AM

77331

Page 3

Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 12/5/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	SB	12/01/16		1	0		
170 *170* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 114514 Large Fab Memo 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.	0.00 0.00		12.01.16		1	0		
180 *180* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	Sizelock			41			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77331

Monday, December 05, 2011 11:23:29 AM

77331

Page 4

Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 12/5/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190	QC5- Inspect part completeness to step on W/O	0.00							
190		0.00							
QC	Memo								
Quality Control									

191	Pressure Wash per QSI005 4.3	0.00							
191		0.00							
HandFinish	Memo								
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***								

200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200		0.00							
Powdercoat	Memo								
Powder Coating	START TIME: 1:30 OVEN TEMPERATURE: 320 FINISH TIME: 2:00								

MU480

1X ML 12/04/16
LH

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77331

Monday, December 05, 2011 11:23:29 AM

77331

Page 5

Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 12/5/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC3- Inspect Part Finish	0.00							
210									
QC	Memo	0.00				1	BL	12-1-17	
Quality Control									
220		0.00							
220	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D2842								
	2-Wing Walk as per Dwg D2842 and QSI 005 4.1								
	Batch: <u>12/12/11</u>								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									

8 12/16/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77331

77331

Page 6

Monday, December 05, 2011 11:23:29 AM

Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly, 206 Float
Start Date: 12/5/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/12/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location: _____	0.00							
240									
Packaging	Memo	0.00							
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									

12-02-14

12/2/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 05, 2011 11:23:28 AM

Page 1

Work Order ID: 77331

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 12/5/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10L washer	* NAS1149C0332R	Purchased	No		119736.	100	Each	0.0000	3	3		BL 12-1-26.	
D2622-120C Step Extrusion		Manufactured	No			120	Each	126.5200	1	1		12-01-09	

Location Loc Qty Loc Code

HALL 17.02

46910 2

64409 6

66970 7.7

68293 0.5

72131 0.82

WA 109.5

75781 109.5

D2734

Step End Plate

Manufactured

No

120

Each

25.0000

2

2

12-01-10

Location Loc Qty Loc Code

WA015 25

73416 25

D3459-1

Float Step Mounting Plate

Manufactured

No

220

Each

17.0000

2

2

12-01-10

Location Loc Qty Loc Code

WA002 15

74517 15

WA017 2

73319 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 05, 2011 11:23:28 AM

Page 2

Work Order ID: 77331

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 12/5/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3459-3
Float Step Mounting Plate

Manufactured No

120 Each 13.0000

2

2

12-01-10

Location

Loc Qty

Loc Code

WA002

2

62956

2

WA017

11

73320

11

MS27039C1-07

screw

Purchased

No

220 Each 33.0000

3

3

BL 12-1-20

Location

Loc Qty

Loc Code

ST293

33

117423

8

118686

25

NAS1329C3KB130

insert

Purchased

No

220 Each 82.0000

3

3

BL 12-1-20

Location

Loc Qty

Loc Code

ST276

82

117679 ✓

7

118984

75

NAS1515H3L

WASHER

Purchased

No

220 Each 131.0000

3

3

BL 12-1-20

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

91

118686

3

119438 ✓

88

3



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

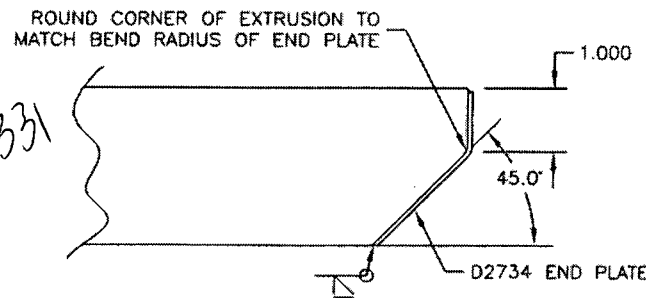
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN KE	DRAWING BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. B
CHECKED 	APPROVED 	DRAWING NO. D2842	SHEET 1 OF 1	
DATE 05.09.23		TITLE 206L/407 FLOAT STEP ASSEMBLY NTS		
A	98.10.13	NEW ISSUE		
B	05.09.23	RE-DESIGN, ADD D3459-1/-3		



RELEASED
8-11-14

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-11B	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN950C10L	WASHER

- D2842-041/-042 FLOAT STEP ASSEMBLY** **NOT TO SCALE**
- 1) MAKE FROM EXTRUSION D2622
 - 2) WELD PER DART QSI 004
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

Copyright © 2005 by DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries